









# Blending Solvent

Programmed System Technique (PST)  
Mixing Thinners  
8/25/2017

## DESCRIPTION

Lesonal Blending Solvent is a specialty material designed for dissolving the overspray and fade out edge created during spot repairing and blending. Lesonal Blending Solvent can be used with any Lesonal clearcoat.

<b>Fade Out Edge Preparation</b> 	<ul style="list-style-type: none"> <li>Prepare the full-strength topcoat or clearcoat application area with P1000 on a D/A with interface pad or a gray scuff pad and Lesonal Plast-O-Blend.</li> <li>Prepare the ready to spray paint + Lesonal Blending Solvent application area with a gold scuff pad or damp sponge and Lesonal Plast-O-Blend. The area must extend past the intended melt-in area.</li> </ul>						
<b>Use with Ready to Spray Paint</b> 	<ul style="list-style-type: none"> <li>For blending applications, prepare the clearcoat as described in the clearcoat TDS then add Lesonal Blending Solvent.</li> </ul>						
<b>Mixing</b> 	<table> <tr> <td><b>Mix</b></td><td><b>Clearcoat By Volume</b></td></tr> <tr> <td><b>100</b></td><td>Ready to spray clear coat</td></tr> <tr> <td><b>50</b></td><td>Lesonal Blending Solvent</td></tr> </table>	<b>Mix</b>	<b>Clearcoat By Volume</b>	<b>100</b>	Ready to spray clear coat	<b>50</b>	Lesonal Blending Solvent
<b>Mix</b>	<b>Clearcoat By Volume</b>						
<b>100</b>	Ready to spray clear coat						
<b>50</b>	Lesonal Blending Solvent						
<b>Equipment</b> 	<table> <tr> <td> <b>Clearcoat + Blending Solvent Spray-Gun:</b> <ul style="list-style-type: none"> <li>1.3 – 1.5 mm HVLP Gravity</li> <li>1.3 – 1.5 mm Compliant Gravity</li> </ul> </td><td> <b>Reduce Application Air Pressures:</b> <ul style="list-style-type: none"> <li>HVLP – 6-8 psi (.41-.55 bar) at the air cap.</li> <li>Consult manufacturer specifications.</li> </ul> </td></tr> </table>	<b>Clearcoat + Blending Solvent Spray-Gun:</b> <ul style="list-style-type: none"> <li>1.3 – 1.5 mm HVLP Gravity</li> <li>1.3 – 1.5 mm Compliant Gravity</li> </ul>	<b>Reduce Application Air Pressures:</b> <ul style="list-style-type: none"> <li>HVLP – 6-8 psi (.41-.55 bar) at the air cap.</li> <li>Consult manufacturer specifications.</li> </ul>				
<b>Clearcoat + Blending Solvent Spray-Gun:</b> <ul style="list-style-type: none"> <li>1.3 – 1.5 mm HVLP Gravity</li> <li>1.3 – 1.5 mm Compliant Gravity</li> </ul>	<b>Reduce Application Air Pressures:</b> <ul style="list-style-type: none"> <li>HVLP – 6-8 psi (.41-.55 bar) at the air cap.</li> <li>Consult manufacturer specifications.</li> </ul>						
<b>Application</b> 	<b>Clearcoat + Lesonal Blending Solvent Application</b> <ul style="list-style-type: none"> <li>Control application to restrict the overspray to the edge of the application.</li> <li>Apply 1 thin coat of clearcoat mixed with Blending Solvent over the full strength clearcoat overspray edge and extending into the prepared existing finish.</li> <li>Apply a second application after a short flash if needed.</li> </ul>						
<b>Application</b> 	<b>Pure Lesonal Blending Solvent Application</b> <ul style="list-style-type: none"> <li>Lower pressure again to apply pure Lesonal Blending Solvent and check the spray pattern.</li> <li>Apply 1 thin coat to the edge of the clearcoat + Lesonal Blending Solvent edge.</li> <li>If needed apply a second or third coat of Lesonal Blending Solvent after a short flash.</li> </ul>						
<b>Flash-off</b> 	<table> <tr> <td> <b>Flash Between Coats at 70°F (21°C)</b> <ul style="list-style-type: none"> <li>Clearcoat, 1-3 minutes.</li> <li>Lesonal Blending Solvent, 15-30 seconds.</li> </ul> </td><td> <b>Flash Before Force Drying at 70°F (21°C)</b> <ul style="list-style-type: none"> <li>Refer to the mixed product TDS for flash and bake recommendations.</li> </ul> </td></tr> </table>	<b>Flash Between Coats at 70°F (21°C)</b> <ul style="list-style-type: none"> <li>Clearcoat, 1-3 minutes.</li> <li>Lesonal Blending Solvent, 15-30 seconds.</li> </ul>	<b>Flash Before Force Drying at 70°F (21°C)</b> <ul style="list-style-type: none"> <li>Refer to the mixed product TDS for flash and bake recommendations.</li> </ul>				
<b>Flash Between Coats at 70°F (21°C)</b> <ul style="list-style-type: none"> <li>Clearcoat, 1-3 minutes.</li> <li>Lesonal Blending Solvent, 15-30 seconds.</li> </ul>	<b>Flash Before Force Drying at 70°F (21°C)</b> <ul style="list-style-type: none"> <li>Refer to the mixed product TDS for flash and bake recommendations.</li> </ul>						
<b>Drying</b> 	<ul style="list-style-type: none"> <li>Refer to the mixed and applied product TDS for drying recommendations.</li> </ul>						

Read complete technical data sheet for detailed product information

# Blending Solvent

Technical Data Sheet  
Mixing Thinners  
8/25/2017  
Page 2 of 5

## DESCRIPTION

Lesonal Blending Solvent is a specialty material designed for dissolving the overspray and fade out edge created during spot repairing and blending. Lesonal Blending Solvent can be used with any Lesonal clearcoat.

### Blending of Clearcoat



- AkzoNobel strongly recommends the application of clear coat over the entire panel being repaired. There are, however, instances where this is not practical. Such as repairs on older vehicles where economics would dictate that a warranty is not required. In these instances, it may be acceptable to solvent blend the clear coat into small areas such as a rocker panel, sail panel or on vertical areas only.
- Solvent blending techniques and procedures explained in this TDS are not warranted by AkzoNobel or OEM approved.

### Suitable Substrates



- Refer to TDS for the paint product that Lesonal Blending Solvent will be used with for information on suitable substrates.

## COMPATIBLE PRODUCTS

### Product

- Basecoat SB
- Lesonal Acrylic Urethane Clearcoats

## PRODUCTS AND ADDITIVES

### Product

- Lesonal Blending Solvent, Quart — Item #398298

Note: Lesonal Blending Solvent is only suitable for use in National Rule VOC areas. For VOC regulated markets use Lesonal Blending Solvent LV Item #481066

## METHOD OF USE

### Basic Row Materials

- Lesonal Blending Solvent — Specially formulated solvents

### Substrate Preparation

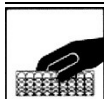


#### Pre-Cleaning

- If needed pre-wash the repair with warm soap and water. Rinse completely with clean water.
- Clean with Lesonal Surface Cleaner, Autoprep Ultra Prep (VOC compliant) or Plastic Surface Cleaner.

# Blending Solvent

Technical Data Sheet  
Mixing Thinners  
8/25/2017  
Page 3 of 5



## Fade Out Edge Preparation

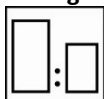
- Prepare the full strength clearcoat application area with P1000 on a D/A with interface pad or a gray scuff pad and Lesonal Plast-O-Blend.
- Prepare the ready to spray paint + Lesonal Blending Solvent application area with a gold scuff pad or damp sponge and Lesonal Plast-O-Blend. The area must extend past the intended melt-in area.



## Surface Cleaning – Prior to Paint Application

- Clean with Lesonal Surface Cleaner, Autoprep Ultra Prep (VOC compliant) or Plastic Surface Cleaner.

## Mixing



BY VOLUME

## Mixing For Spray Gun Application

**100** parts Ready to Spray Paint  
**50** parts Lesonal Blending Solvent

## Potlife when Mixed



- The recommended potlife does not change with the addition of Lesonal Blending Solvent.
- Refer the TDS of the product being applied for potlife information.

## Spray Gun Set-Up



### Clearcoat + Blending Solvent

#### Spray-Gun:

- 1.3 – 1.5 mm HVLP Gravity
- 1.3 – 1.5 mm Compliant Gravity

### Reduce Application Air Pressures:

- HVLP – 6-8 psi (.41-.55 bar) at the air cap.
- Consult manufacturer specifications.

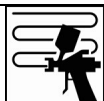
## APPLICATION TECHNIQUE

### Application Lesonal Blending Solvent



### Clearcoat + Lesonal Blending Solvent

- Control application to restrict the overspray to the edge of the application.
- Apply 1 thin coat of clearcoat mixed with Blending Solvent over the full-strength overspray edge and extending into the prepared existing finish.
- Apply a second application after a short flash if needed.



### Optional Pure Blending Solvent Application

- This optional application provides the smoothest transition and minimizes detailing work later.
- Lower pressure again to apply pure Lesonal Blending Solvent and check the spray pattern.
- Apply 1 thin coat to the edge of the clearcoat Lesonal Blending Solvent edge.
- If needed apply an additional coat of Lesonal Blending Solvent after a short flash.

# Blending Solvent

Technical Data Sheet  
Mixing Thinners  
8/25/2017  
Page 4 of 5

## Drying / Curing Time



- Dry the applied paint according to its TDS specifications.
- Additional drying with infrared will provide the most favorable through hardening in the blend area and less chance of damaging it during detail.
- If the paint is baked, follow the product TDS recommendations for cool down before detailing.

## POST-APPLICATION

### Recoating



- Refer to the applied product TDS for information on recoating.

### Detailing / Polishing



- Polish the blended area by hand with 3M #06064 Perfect-It Machine Polish or a similar fine polishing compound. Do not use an abrasive polishing compound.
- In case more effort is required, polish by machine, using light pressure and a 3M #05707 Perfect-It Foam Polish Pad. Final clean up with a 3M #06016 Perfect-It Detail Cloth.
- After polishing the area may be waxed with a silicone free wax.

## ADDITIONAL INFORMATION

### Cleaning of Equipment



- Clean equipment following local and federal regulations. In compliant localities, use a VOC compliant high-quality solvent borne gun cleaner. For national rule regions, a use high quality lacquer thinner.
- For efficient cleaning and less evaporated cleaning solvents, an enclosed automatic gun cleaning machine is suggested.

### VOC / Regulatory Information



Product	VOC Pounds per Gallon	VOC Grams per Liter
Lesonal Blending Solvent	7.0	840

### Product Storage



- Stock unopened or used products in approved closed containers with proper labelling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (21°C)
- Lesonal Blending Solvent – 1 Year

# Blending Solvent

Technical Data Sheet  
Mixing Thinners  
8/25/2017  
Page 5 of 5

**AkzoNobel Inc., North America**  
**Address: 1845 Maxwell Street, Troy, MI 48084 USA**  
**Telephone: 800-618-1010**

## FOR PROFESSIONAL USE ONLY

**IMPORTANT NOTE:** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

Brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel.

**Head Office**  
Akzo Nobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. [www.Lesonalcr.com](http://www.Lesonalcr.com)